












Date: Thursday, 12/13/2007 2:39:04 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT BRACKET
Job Number	: 36329		
Estimate Number	: 11692		
P.O. Number	: <i>NA</i>	Part Number	: D2705
This Issue	: 12/13/2007 S.O. No. : <i>NA</i>	Drawing Number	: D2705 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 29040	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/20/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>20</i> Um: Each
Comment	Est. B 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:C Now On Waterjet JLM 06-10-24		
Additional Product			
Job Number: 			
Seq. #	Machine Or Operation:	Description :	
1.0	M6061T6S063	6061-T6 .063 Sheet	
			
Comment: Qty.: 0.0437 sf(s)/Unit Total : 0.4368 sf(s) 6061-T6 .063 Sheet Material: 6061-T6 or 5052 H32 or 2024-T3 .0063" thick Batch: <i>100285</i> <i>13 07-12-14</i>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D2705 ***GRAIN DIRECTION SHOULD BE ALONG 1.750" DIM***** Dwg Rev: <i>A</i> Prog Rev: <i>A</i> <i>13 07-12-14</i> 2-Deburr if necessary <i>[Signature]</i>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>13 07-12-14</i>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <i>[Signature]</i>			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Bend on brake as per Dwg D2705 <i>[Signature]</i>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PC Date: 07/12/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SUPPORT BRACKET

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/18 x 24

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07/12/19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/12/19

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5744

07/12/18 (24)

10.0

QC21

FINAL INSPECTION/W/O RELEASE.



Comment: FINAL INSPECTION/W/O RELEASE

07/12/20

Job Completion



07/12/20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

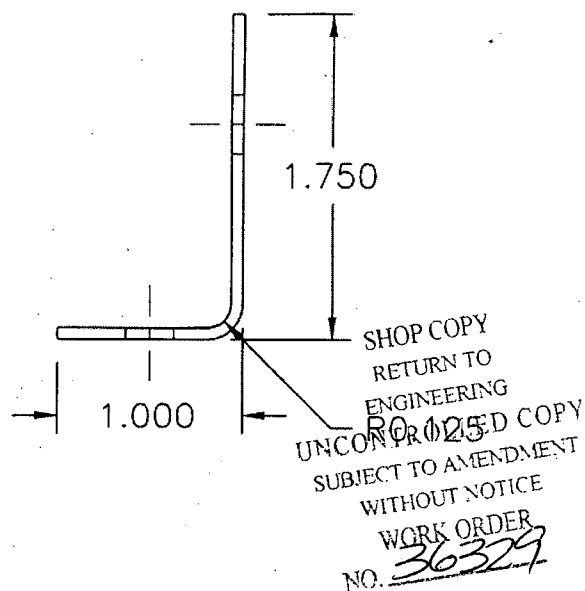
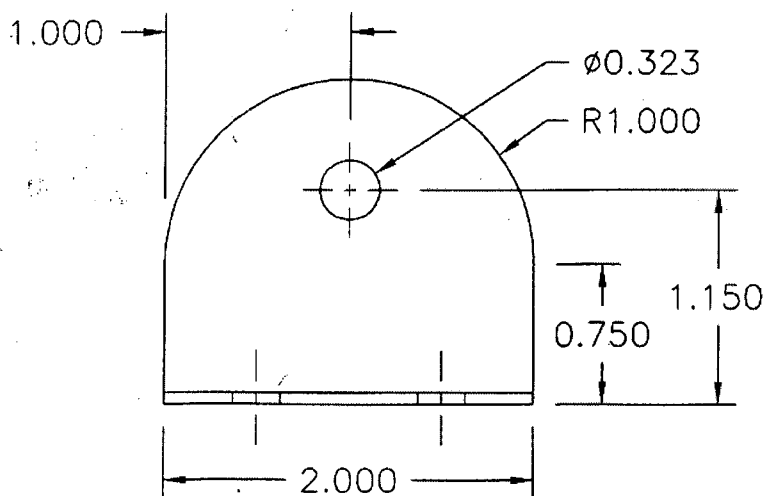
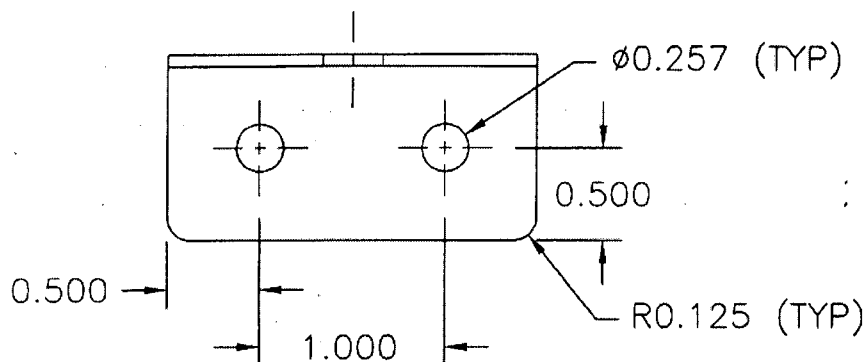
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>mm</i>	APPROVED <i>KE</i>	DRAWING NO. D2705	REV. A SHEET 1 OF 1
DATE 97.10.10		TITLE SUPPORT BRACKET	SCALE 1:1
A	97.10.10	NEW ISSUE	

RELEASED
471023 KE



MATERIAL: 5052-H32 (QQ-A-250/8) OR 2024-T3 (QQ-A-250/4)
OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

